

# Work Order ID 57702



Page 1

April 14, 2010 8:26:28 AM

Item ID:	D212-601-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Utility-Pod RH, 205/212/214/412					
Start Date:	5/28/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/04/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/4/14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D212-601	B

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file & create labels per PPP D212-601-042 CHG002								

8/10/09/29

H for BG 10-9-28

110		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging									

10/9/28 SP

120		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

8/10/09/29

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57702**

April 14, 2010 8:26:28 AM



Page 2

Item ID: D212-601-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod RH, 205/212/214/412

Start Date: 5/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/04/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD212-601-042

Location:

PPP Rev: DRAFT10/10/29 (1)

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/09/29 HJMR  
10-9-29

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**NOTE:** Date & initial all entries

# Picklist Print

April 14, 2010 8:26:27 AM

Page 1

Work Order ID: 57702

Parent Item: D212-601-042

Parent Item Name: Heli-Utility-Pod RH, 205/212/214/412



Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Date: 5/28/10

Required Date: 6/04/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3192-042  pod assembly		Purchased	No				Each	0.0000	1.0000			
D2199-5  Strut Details		Manufactured	No				Each	4.0000	1.0000			

B57701

10/09/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST272

4

40616

4

Manufactured No

Each

4.0000

1.0000

1

10/9/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST272

4

40617

4

Manufactured No

Each

1.0000

1.0000

1

10/9/2008

Warehouse

Loc Qty

Loc Code

Location

Premier

Mezz

22497

1

1

1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli-Utility-Pod RH, 205/212/214/412

Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-5A  Bolt		Purchased	No				Each	321.0000	3.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST356

321

112933

21

114108

100

114330

200

AN4-7A



Bolt

Purchased

No

Each

249.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST356

249

113226

249

AN4-10A



Bolt

Purchased

No

Each

72.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST356

72

111425

22

113422

50

April 14, 2010 8:26:28 AM

Shop Packet Print

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

April 14, 2010 8:26:28 AM

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Parent Item Name: Heli-Utility-Pod RH, 205/212/214/412

Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN5-7A		Purchased	No				Each	206.0000	1.0000			
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Bolt

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST337

206

113149

200

113226

6

AN5-10A		Purchased	No				Each	189.0000	1.0000			
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Bolt

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST337

189

114056

39

114199

100

114227

50

AN960JD416		Purchased	No				Each	0.0000	12.0000			
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Washer

AN960JD516		Purchased	No				Each	0.0000	3.0000			
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Washer

WAS1149004635

WAS1149005635

10/9/28

1

11/15/10 10/9/28

11/15/22 10/9/28

11/14/42 10/9/28

April 14, 2010 8:26:28 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Parent Item Name: Heli-Utility-Pod RH, 205/212/214/412



Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No				Each	1,362.000	7.0000			
												
Nut												

MI15108 10/09/28 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

1360

113422

368

114108

984

9063

8

MS21042L5

Purchased

No



Nut

Each

365.0000

2.0000



MI15156 10/9/28 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

365

113523

26

113537

139

114108

200

April 14, 2010 8:26:28 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	Qty -041	Qty -042	PART NUMBER	DESCRIPTION
1	X		D3192-041	UTILITY POD ASSEMBLY, LH
2		X	D3192-042	UTILITY POD ASSEMBLY, RH
5	1	1	D3192-1	HINGE (MAKE FROM D2569)
9	1	1	D2195	BRACKET
10	1	1	D2196	BRACKET
11	1	1	D2197	BRACKET
12	6	6	D2198-1	BRACKET
13	1	1	D2200-1	POD LID
14	1	1	D2200-3	POD BASE
15	3	3	D2204-6	LATCH
16	2	2	D2204-9	LATCH
17	1	1	D2258-220	PLACARD
18	1	1	D2429-041	SPRING CLIP ASSEMBLY
19	1	1	D2463-1700	NEOPRENE SEAL
20	5	5	D2528-1	BACKER PLATE
21	4	4	D2528-3	BACKER PLATE
30	1	1	D3007-041	PROP ASSEMBLY
31	2	2	D3191-1	BACKER PLATE
32	3	3	D3191-3	BACKER PLATE
33	1	1	D3191-5	BACKER PLATE
40	38	38	AD64ABS	RIVET
41	30	30	AN3-11A	BOLT
42	30	30	AN3-5A	BOLT
43	6	6	AN4-11A	BOLT
44	13	13	AN4-5A	BOLT
45	1	1	AN4-6A	BOLT
46	2	2	AN526C632R7	SCREW
47	60	60	AN960JD10	WASHER
48	21	21	AN960JD416	WASHER
49	2	2	AN960JD6	WASHER
50	2	2	MS21042L06	NUT (OR MS21042-06)
51	60	60	MS21042L3	NUT (OR MS21042-3)
52	20	20	MS21042L4	NUT (OR MS21042-4)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 54 lbs APPROX
- 8) SEAL ALL HOLES AND EDGES OF POD LID (ITEM 13) AND BASE (ITEM 14) WITH CYANOACRYLATE GLUE.
- 9) FOR INSTALLATION OF D3192-1 HINGE:
  - (i) TRANSFER MARK AND DRILL POD LID (ITEM 13) AND BASE (ITEM 14) Ø0.191
  - (ii) INSTALL RIVET HEADS FROM OUTSIDE OF POD.
  - (iii) GRIND TRAILING EDGE OF RIVET TO 0.100 IN HEIGHT TO PERMIT HINGE TO CLOSE.
- 10) FOR HOLES DRILLED THROUGH FOAM CORE:
  - a) DRILL Ø0.313" HOLES THROUGH POD.
  - b) CLEAN OUT FOAM Ø0.250" AROUND HOLE BETWEEN INNER AND OUTER SKINS.
  - c) APPLY TAPE TO UNDERSIDE OF SKIN (TO STOP EPOXY FILLER GOING THROUGH).
  - d) FILL CAVITY BETWEEN SKINS COMPLETELY WITH "HYSOL EA934" OR SIMILAR EPOXY POTTING COMPOUND.
  - e) AFTER THE EPOXY HAS COMPLETELY CURED, DRILL Ø0.257 FINISH HOLE SIZE FOR AN4 BOLT OR Ø0.191 FINISH HOLE SIZE FOR AN3 BOLT.
- 11) RELIEVE D2200-1 POD LOCALLY IN AREA OF D2195/D2196/D2197 BRACKETS TO CLEAR BRACKETS.
- 12) INSTALL D3191-1/-3/-5 BACKER PLATE USING SIKAFLEX -241/-291 ADHESIVE.

W10: 5702

C21014/14

**RELEASED**  
09/01/15

B	DRAWING TRANSFERRED TO "B" SIZE AND REDRAWN WITH CURRENT STANDARDS. -1 HINGE ADDED. ADDED ITEM 33 (SEE NCR 08-110).		AJS	09.01.05
A	NEW ISSUE		DS	03.07.01
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3192 REV. B SHEET 1 OF 4 TITLE: UTILITY POD ASSEMBLY SCALE: NTS DATE: 09.01.05 <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				

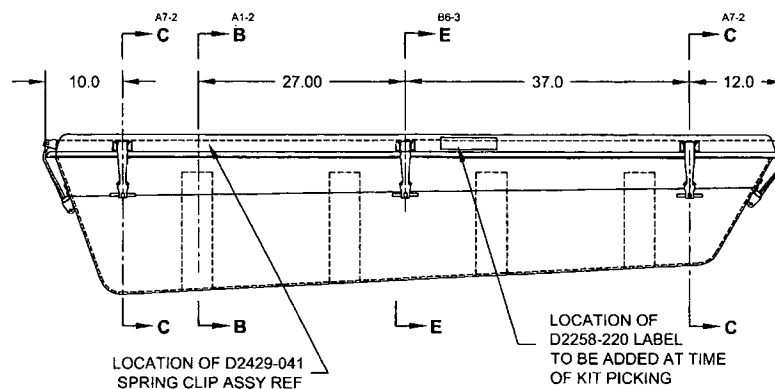
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

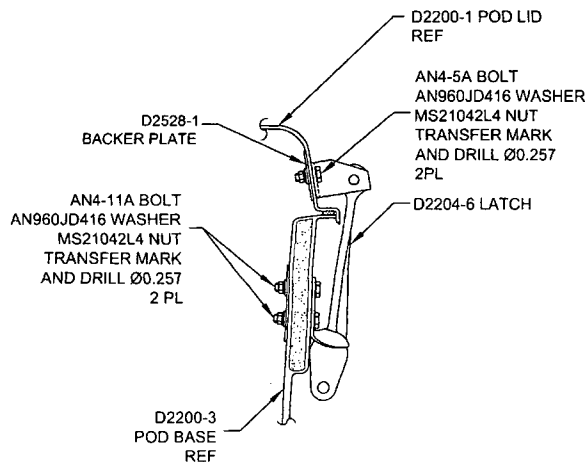
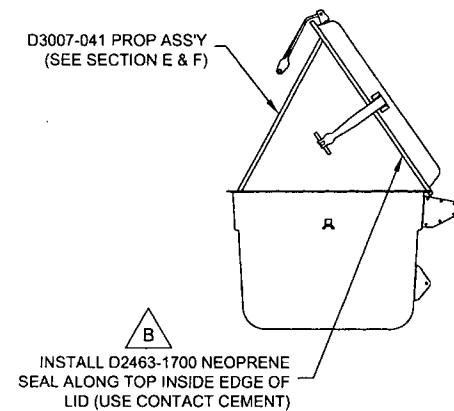
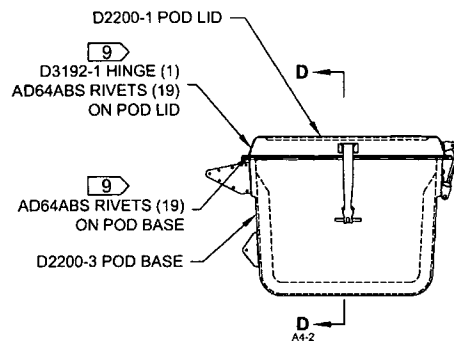
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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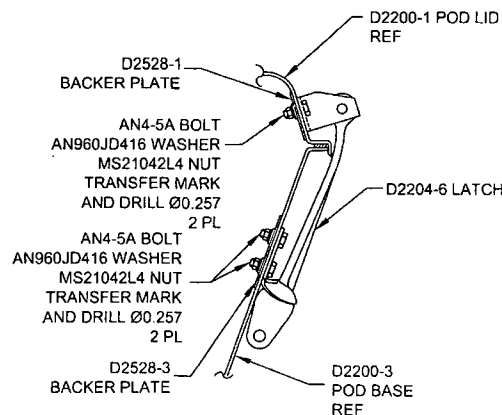
**NOTE:** Date & initial all entries



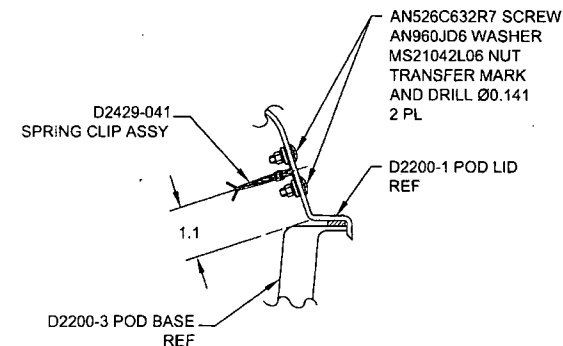
**D3192-041 UTILITY POD ASSEMBLY, LH (SHOWN)**  
**D3192-042 UTILITY POD ASSEMBLY, LH (OPPOSITE)**



**SECTION C-C** D3-2  
SCALE 4X D6-2






**SECTION D-D** C7-2  
SCALE 4X



**SECTION B-B** D5-2  
SCALE 6X

**RELEASED**  
 09/01/15

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3192	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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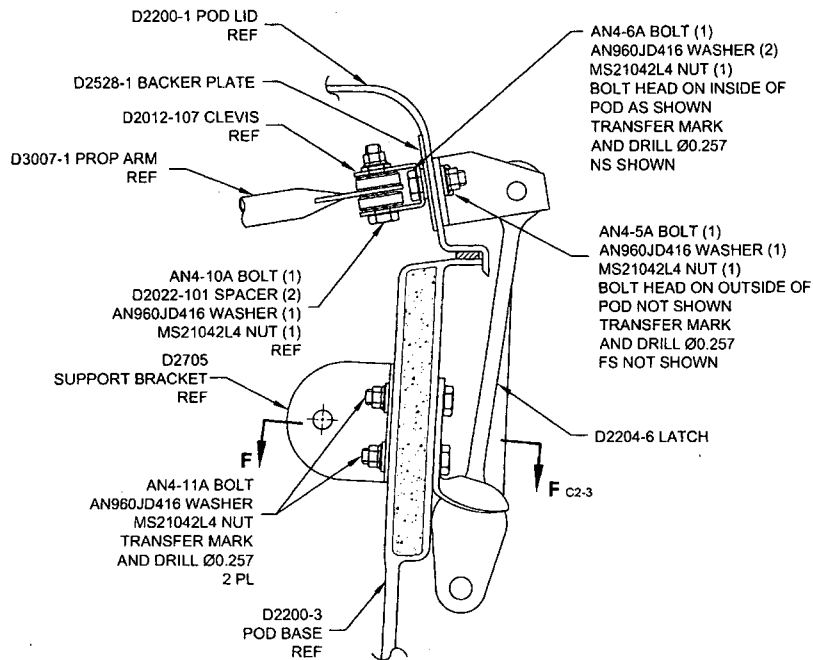
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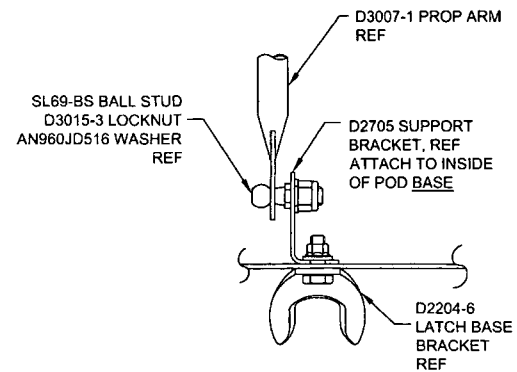
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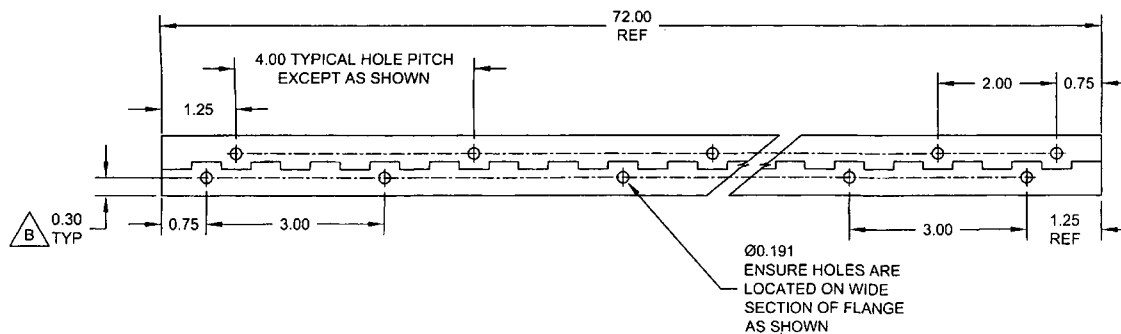




**SECTION E-E** D4-2



**SECTION F-F** C5-3  
ROTATED 85° CW



**D3192-1 HINGE**  
(MAKE FROM D2569)

**RELEASED**  
09/01/15

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3192	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

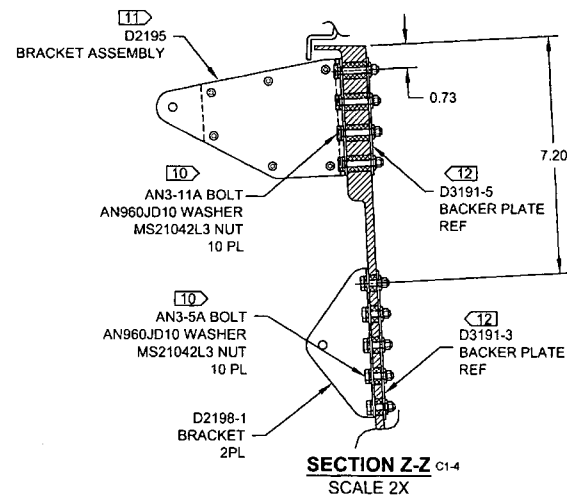
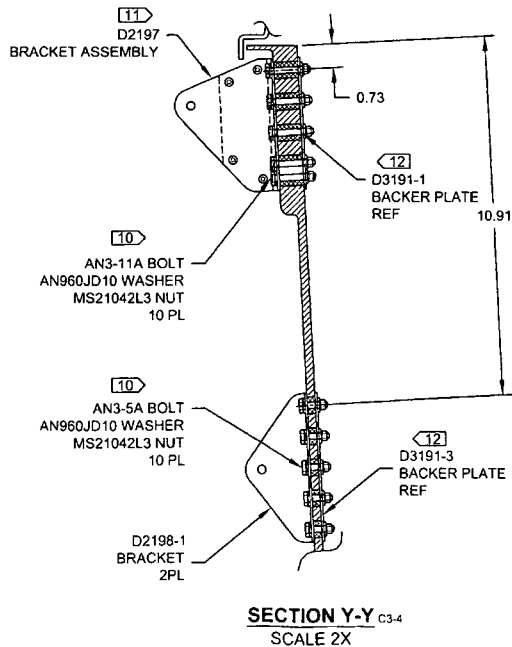
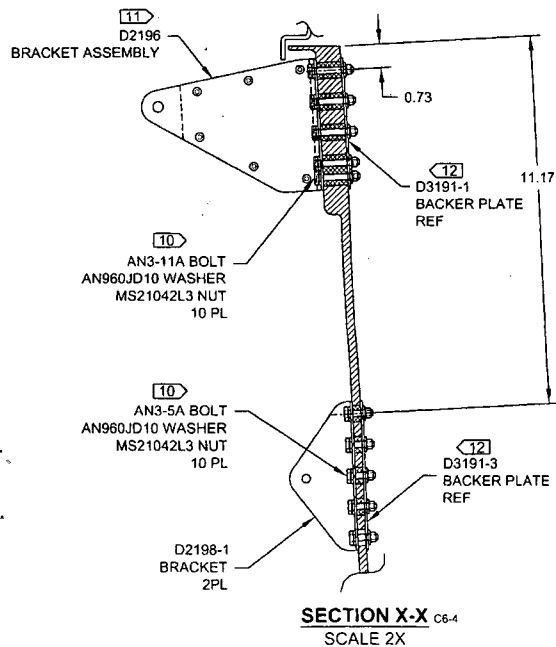
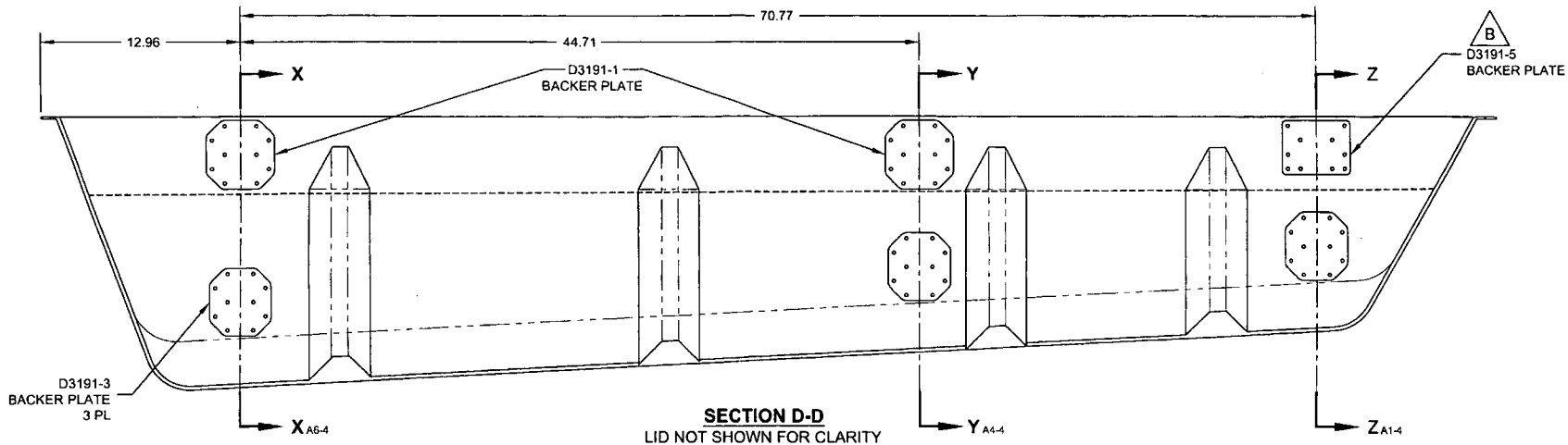
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DRAWN	AJS		
CHECKED		DRAWING NO. D3192	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	09.01.05	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
09/01/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5. PARTS LIST

Qty -041	Qty -042	Part Number	Description
X		D212-601-041	HELI-UTILITY-POD LH
	X	D212-601-042	HELI-UTILITY-POD RH
1		D3192-041	POD ASSEMBLY
	1	D3192-042	POD ASSEMBLY
1	1	*D2195	BRACKET
1	1	*D2196	BRACKET
1	1	*D2197	BRACKET
6	6	*D2198-1	BRACKET
1	1	*D2200-1	LID
1	1	*D2200-2	BASE
3	3	*D2204-6	LATCH
2	2	*D2204-9	LATCH
1	1	*D2258-220	PLACARD
1	1	*D2429-041	SPRING CLIP ASSEMBLY
1	1	*D2462-1700	NEOPRENE SEAL
5	5	*D2528-1	BACKER PLATE
4	4	*D2528-3	BACKER PLATE
1	1	*D2569	HINGE
1	1	*D3007-041	PROP ASSEMBLY
3	3	*D3191-1	BACKER PLATE
3	3	*D3191-3	BACKER PLATE
38	38	*AD64ABS	RIVET
30	30	*AN3-10A	BOLT
30	30	*AN3-4A	BOLT
13	13	*AN4-5A	BOLT
1	1	*AN4-6A	BOLT
6	6	*AN4-11A	BOLT
2	2	*AN526C632R7	SCREW
2	2	*AN960JD6	WASHER
60	60	*AN960JD10	WASHER
21	21	*AN960JD416	WASHER
60	60	*MS21042L3	NUT (OR -3)
20	20	*MS21042L4	NUT (OR -4)
2	2	*MS21042L06	NUT (OR -06)
1	1	D2199-2	STRUT
1	1	D2199-7	STRUT
1	1	D2199-9	STRUT
3	3	AN4-5A	BOLT
2	2	AN4-7A	BOLT
2	2	AN4-10A	BOLT
1	1	AN5-7A	BOLT
1	1	AN5-10A	BOLT
12	12	AN960JD416	WASHER
3	3	AN960JD516	WASHER
7	7	MS21042L4	NUT (OR -4)
2	2	MS21042L5	NUT (OR -5)

\*INCLUDED IN D3192-041/-042 ASSEMBLIES LISTED ABOVE

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Revision: B

Date: 03.06.02

→ D2199-5  
OK  
MD  
10/9/28